

Work Order ID 123280

123280

Page 1

August-06-14 1:11:10 PM

Item ID: D4473-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Small Rib Assembly, RH
 Start Date: 8/06/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4473	REV B

100		0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 2.5" LONG								

110		0.00							
110									
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>25345</u> TO ARCHUR PRESISION(GLOBUS) C OF C IS REQUIRED								

115	Receive & Inspect for Damage & Mat'l Certs	0.00							
115									
Packaging	Memo	0.00							
Packaging									

Handwritten notes:
 14/8/11
 8/24/15 (2)
 8/23/23 (2)

Quality Control

Work Order ID 123280

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123280

Page 3

Item ID: D4473-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Small Rib Assembly, RH
 Start Date: 8/06/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
141	Spray Painting per QSI005 4.2	0.00							DAS 41 9-89
141						2			
SprayPaint	Memo	0.00							14-9-25
Spray Painting	PRIME TEMPO GREY 128927								
142	QC14- Inspect Spray Paint	0.00							DAS 9 9-89
142						2	14-08-25		
QC	Memo	0.00							
Quality Control									
150		0.00							
150						2x			14/09/26
Small Fab	Memo	0.00							DAS 36 9-89
Small Fab	install nutplates as per dwg								

Work Order ID 123280

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123280

Page 4

Item ID: D4473-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Small Rib Assembly, RH
 Start Date: 8/06/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160						(2)			DAS 38 9-89 14-9-26
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: MF	0.00							
200						2x		SEP 26 2014	DAS 28 9-89
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									MLJ 14-09-26
QC	Memo	0.00							
Quality Control									

MLJ 14-09-26

Picklist Print

August-06-14 1:11:10 PM

Page 1

Work Order ID: 123280

123280

Parent Item: D4473-042

D4473-042

Parent Item Name: Small Rib Assembly, RH

Start Date: 8/06/14

Required Date: 8/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-01-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No				f	102.2990		1			
<p><i>WZT supplied by Archer</i></p> <p>*M6061T6B1 000X04 000*</p> <p>6061-T6 Bar 1.00 x 4.00</p>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT003			102.299						
				124681			23.7						
				M126160			10						
				M127797			20.349						
				M128980			0.25						
				M129167			48						
D4473-1P		Purchased	No				Each	0.0000		2			
<p>*D4473-1P*</p> <p>Small Rib, LH</p>													
MS20426AD3-4		Purchased	No				Each	5,584.000		4			
<p>*MS20426AD3-4*</p> <p>RIVET</p>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST315			5584						
				125578			3066						
				m127432			2518						

DAS
36
9-89

Picklist Print

August-06-14 1:11:10 PM

Page 2

Work Order ID: 123280

123280

Parent Item: D4473-042

D4473-042

Parent Item Name: Small Rib Assembly, RH

Start Date: 8/06/14

Required Date: 8/15/14

Start Qty: 2.00

Required Qty: 2.00

MS21059L08

Purchased

No

Each

735.0000

2

MS21059L 08

**

14/09/26

DAS
36
9-89

Nut

Location

Loc Qty

Loc Code

ST304

225

m129934

225

ST508

510

123185

1

125654

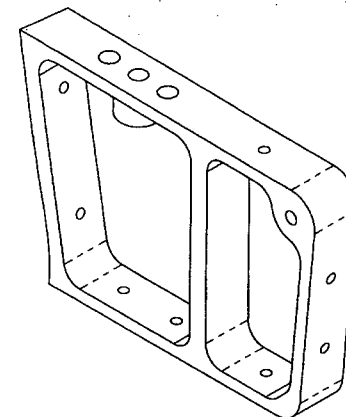
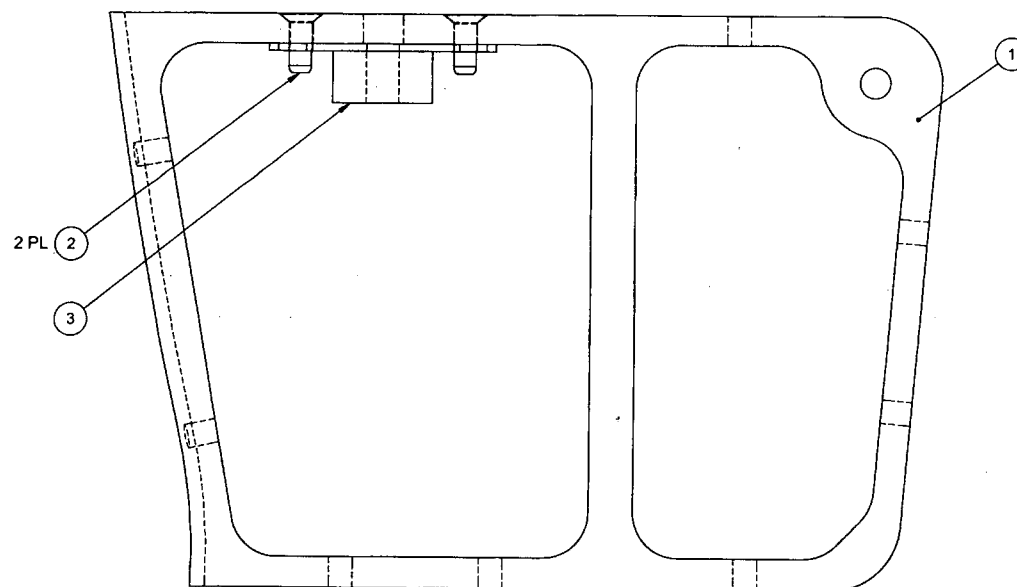
505

m124291

4

2

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4473-042	SMALL RIB ASSY (RH)
1	1	D4473-2	SMALL RIB (RH)
2	2	MS20426AD3-4	RIVET, CSK
3	1	MS21059L08	NUTPLATE



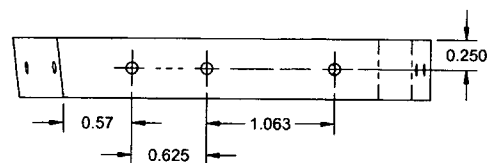
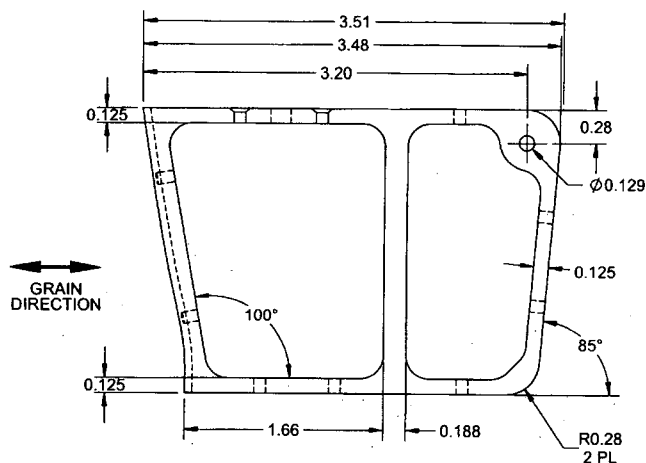
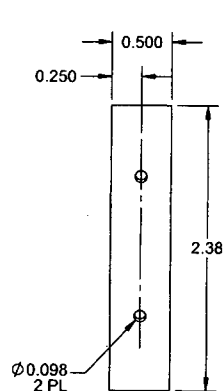
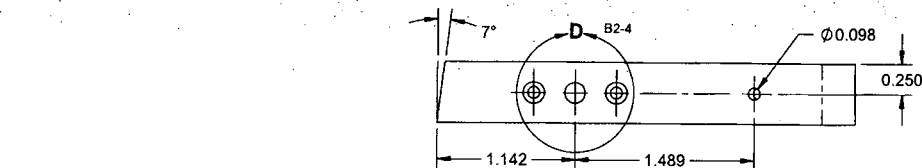
D4473-042 SMALL RIB ASSY (RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

RELEASED
2012-09-18
MPO

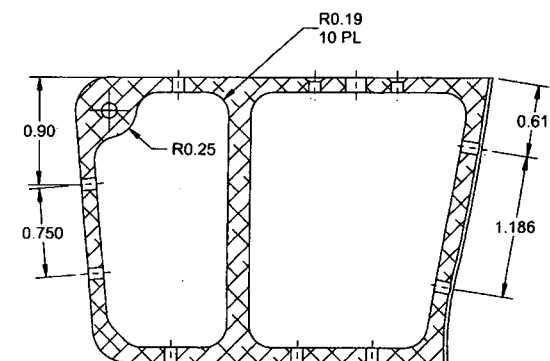
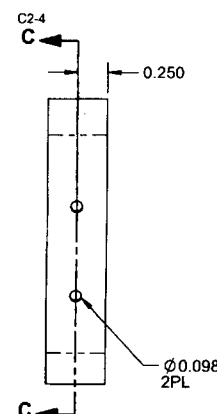
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. D4473	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE SMALL RIB ASSY	SCALE
DE APPR.			NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



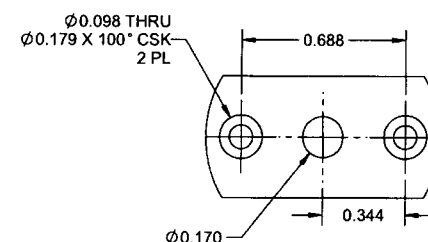
D4473-2 SMALL RIB (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4473-2-REVB.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).





SECTION C-C D4-4



DETAIL D D6-4 (SCALE 2X)

RELEASED
2012-09-18

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.		D4473	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SMALL RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25345**

Purchase Order Date 8/11/2014

PO Print Date 8/11/2014

Page Number 1 of 2

Order From :

VC-GLO001

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	d4476-042p	Small Rib Assembly,RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$164.67	\$329.34
	Manufacture as per Drawing D4476 rev.B Batch 123279						
Line Total:							\$329.34
2	D4473-042P	Smal Rib Assy, RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$164.67	\$329.34
	Manufacture as per Drawing D4473 rev.B Batch#123280						
Line Total:							\$329.34
3	D4494-042P	Upper Block Assy,RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$222.33	\$444.66
	Manufacture as per Drawing B4494 rev.D Batch# 123278						

PO Instructions: Fedex Acc#151793240

Note:

8/11/2014



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

28Aug 2014

Po Number	Part Number	Quantities
25345	D4476-042P	2
	D4473-042P	2
	D4494-042P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 24991 issued by Dart Aerospace Inc.

Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6



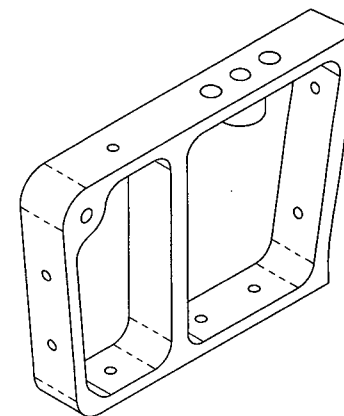
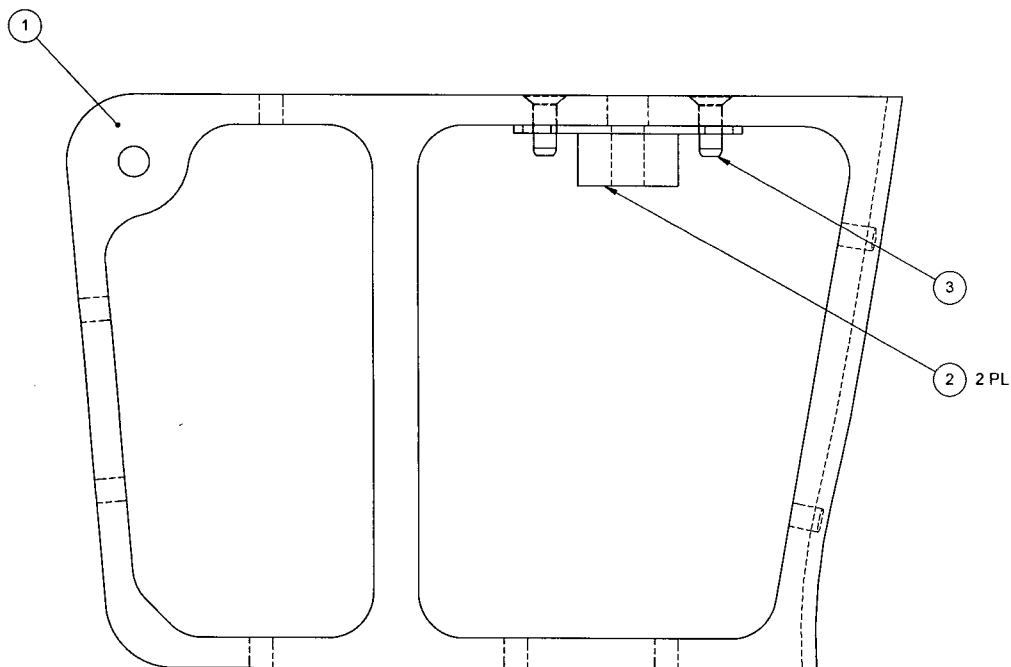
Inspection Report

Customer Name		DART		DWG#		D4473-1		Rev		PB1		Part Name		SMALL RIB		Date		2/9/14		Job #	
Page 1 of 2		Inspection Interval		Special Notes																	
Item #	DWG. Dim	Tolerance	Operator First Off	QA First Off		QA Final															
				A	R	A	R														
1	.500		.498																		
2	2.38		2.376																		
3	.098		.101																		
4	3.48		3.473																		
5	3.20		3.194																		
6	.125		.126																		
7	100°		✓																		
8	1.66		1.657																		
9	.188		.188																		
10	.125		.126																		
11	85°		✓																		
12	.129		.129																		
13	.28		.273																		
14	1.063		1.062																		
15	.625		.624																		
16	.57		.567																		
17	.61		.606																		
18	1.186		1.185																		
19	.90		.892																		
20	.750		.749																		

Inspection Report

[illegible]

ITEM	QTY	P/N	DESCRIPTION
	X	D4473-041	SMALL RIB ASSY
1	1	D4473-1	SMALL RIB
2	1	MS21059L08	NUTPLATE
3	2	MS20426AD3-4	RIVET, CSK



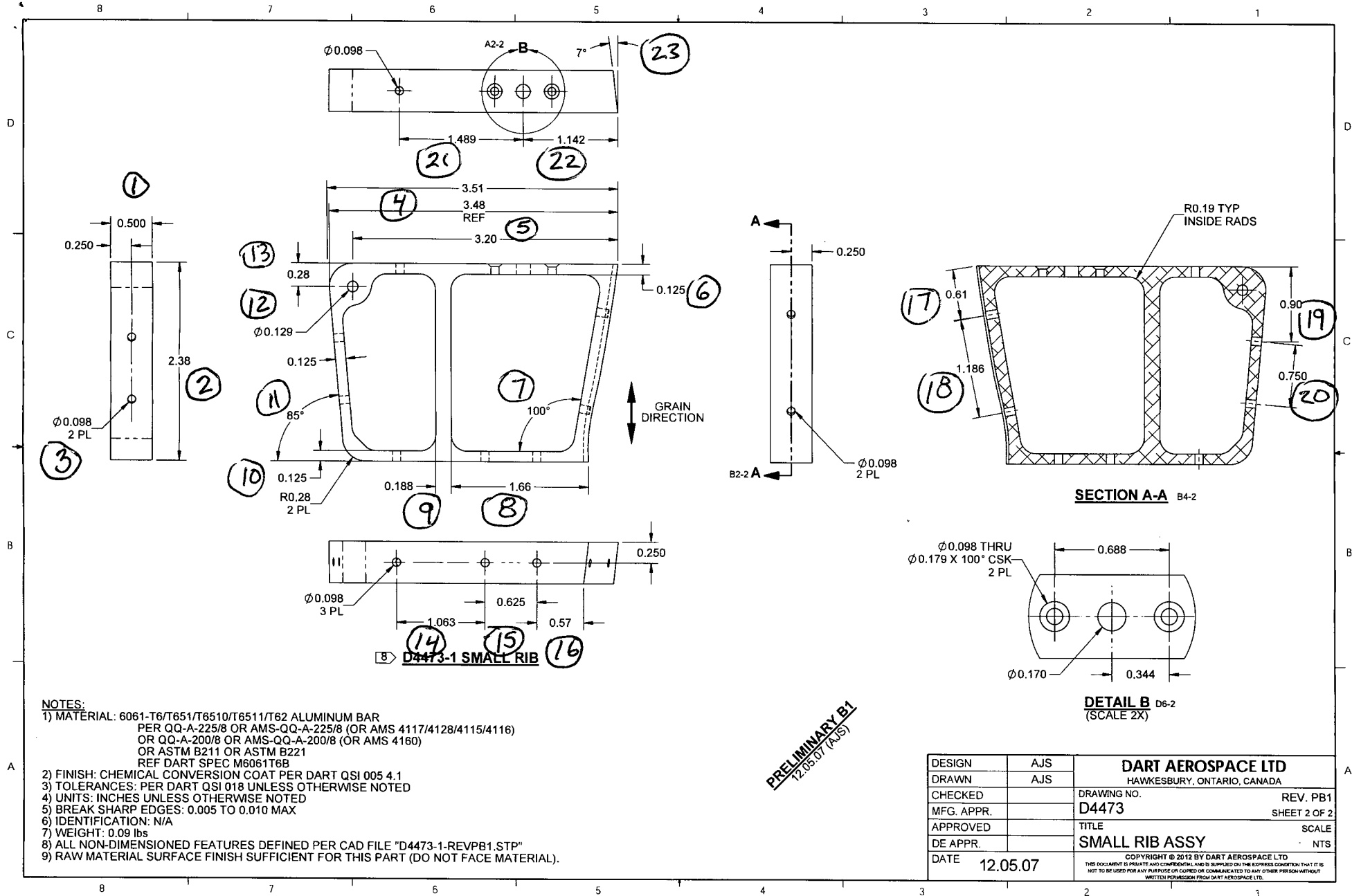
PRELIMINARY B1
12.05.07 (AJS)

D4473-041 SMALL RIB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

PB1	GENERAL REVISION SEE REV. A FOR DETAILS.		AJS	12.05.07
A	NEW ISSUE		AJS	12.03.05
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED			DRAWING NO.	REV. PB1
MFG. APPR.			D4473	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.		SMALL RIB ASSY		NTS
DATE	12.05.07	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

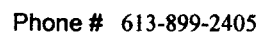


NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4473-1-REV PB1.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART (DO NOT FACE MATERIAL).

PRELIMINARY B1
12.05.07 (AJS)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4473	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SMALL RIB ASSY	NTS
DATE	12.05.07	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Date	Invoice #*
9/17/2014	1169

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
25345	9/17/2014	delivered	Archer	

Qty	Item Code	Description
2	Sales	D4476-2
2	Sales	D4473-2
		HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

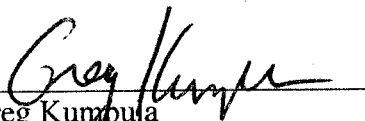
Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

18 September 2013

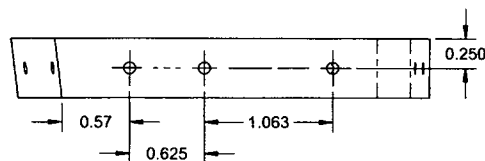
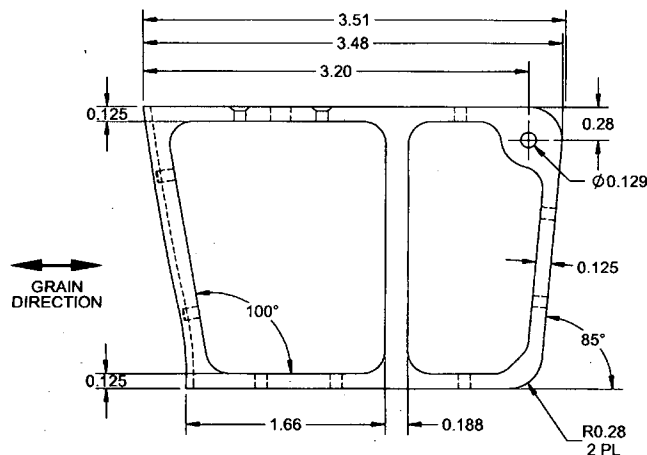
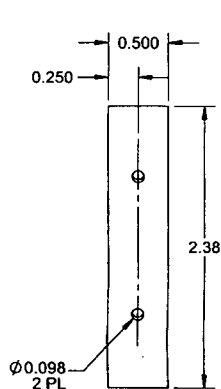
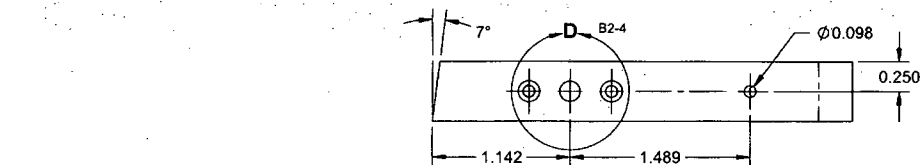
Po Number	Part Number	Quantities
25345	D4476-2P	2
	D4473-2P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 25345 issued by Dart Aerospace Inc.


Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6

Inspection Report

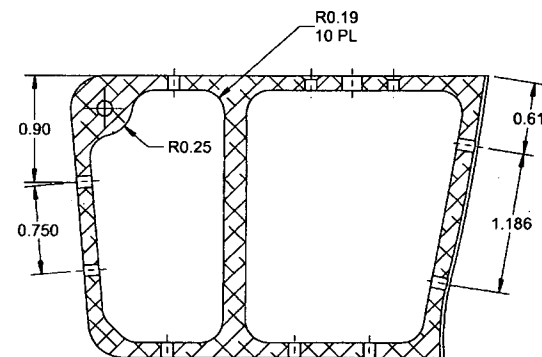
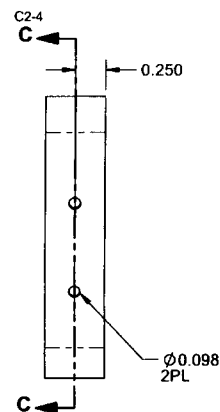
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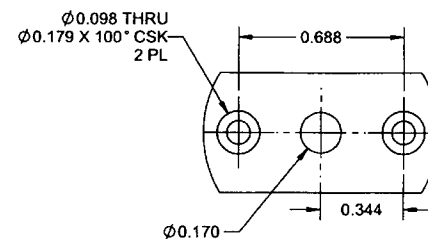
[8] D4473-2 SMALL RIB (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4473-2-REVB.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).





SECTION C-C D4-4



**DETAIL D D6-4
(SCALE 2X)**

RELEASED
2012-09-18

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.		D4473	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SMALL RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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Archer Precision

Short date 9/18/14



Plan Name D4473-2

Part No.: * u_prtnu *

Customer: * u_cus *

Rev.:

u_jobnum * u_jobnum *

u_qtynu * u_qtynu *


Customer PO.: * u_Cuspo *

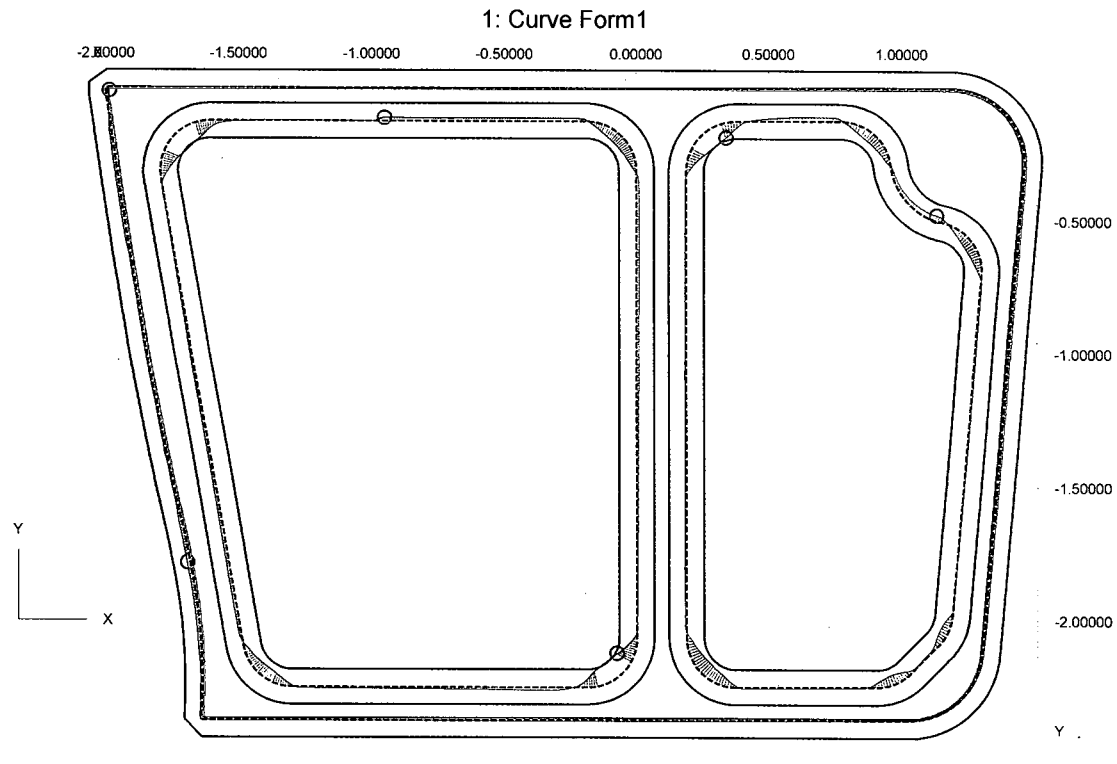
BSN:

u_mtl * u_mtl *

Incr. Smpl No.: 1

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
■ Curve Form1	CurvForm	0.00345	0.00000	0.01000	-0.00100	0.00345	-0.00072
Curve Form2	CurvForm	0.01154	0.00000	0.01000	-0.01000	0.01154	----
Curve Form3	CurvForm	0.01115	0.00000	0.01000	-0.01000	0.01115	----
■ Top Hole Dia	D	0.12893	0.12850	0.00500	-0.00100	0.00043	--
■ OA Height	Z	-0.50014	-0.50000	0.00500	-0.00500	-0.00014	-

		Calypso 5.6.08	Carl Zeiss	Date Order	September 18, 2...
Part Number 1	CMM Type CONT_G2	Drawing No.		Department: Operator	Master
Meas. Plan Name		D4473-2		Signature:	



No	Identifier	Sigma [in]	Form [in]	Number of Points	Lower Tol. [in]	Upper Tol. [in]	MinInd	Min Dev. [in]	MaxInd	Max Dev. [in]	Best Fit	X [in]	Y [in]	Z [in]		X	Y	Z
1	Curve Form1	0.00078	0.00345	998	-0.00100	0.01000	780	-0.00172	944	0.00174	Translation	-0.00201	-0.00080	0.00000	Rotation	0.00000	0.00000	-0.00288
2	Curve Form2	0.00248	0.01154	488	-0.01000	0.01000	218	-0.00307	304	0.00848	Translation	-0.00087	-0.00183	0.00000	Rotation	0.00000	0.00000	-0.00343
3	Curve Form3	0.00224	0.01115	718	-0.01000	0.01000	421	-0.00195	121	0.00920	Translation	-0.00185	-0.00141	0.00000	Rotation	0.00000	0.00000	0.02843

[illegible]